

Amendments to the Claims

This listing of claims replaces all prior versions, and listings, of claims in the application.

Listing of Claims

1. (Currently amended) ~~Process~~ A process for manufacturing a bag (25, 40) from a polymer and/or metal film material, comprising ~~wherein the lower end of the bag (25, 40) is sealed and the bag comprises of four outer walls (A-D) that are connected by four seams (27),~~
~~characterized in that~~
~~the material required for forming the bags (A-E) is fed in the form of a film tube (25, 40) that is wound up on a roll to the unwinding station of a bottom forming device that separates the unwound film tube into film tube segments and seals at least one end of the bag~~
feeding the bag-forming material that is in a form of a single film web and that is wound up on a roll to an unwinding station of a bottom forming device, cutting the unwound film web into four film segments, connecting the four film segments to form a film tube having four outer walls that are connected respectively by four seams, and sealing the connected film segments so as to form at least one sealed end of the bag.

2. (Currently amended) ~~Process pursuant~~ The process according to
claim 1,

~~characterized in that~~

a wherein the film tube ~~(25) is used that already comprises~~
includes side gussets ~~(26)~~.

3. (Currently amended) ~~Process pursuant~~ The process according to
claim 1,

~~characterized in that~~

~~the~~ wherein a bottom of the bag is formed ~~using~~ by transverse
sealing.

4. (Currently amended) ~~Process pursuant~~ The process according to
claim 1,

~~characterized in that~~

~~the~~ wherein a bottom of the bag is formed ~~exclusively~~ by a
squeezing process and a transverse sealing process.

5. (Currently amended) ~~Process pursuant~~ The process according to
claim 1,

~~characterized in that~~

~~the bottom formation of the bag is followed by a filling process of~~
further comprising a step of filling the formed ~~bags~~ bag.

6. (Currently amended) ~~Process pursuant~~ The process according to
claim 1,
~~characterized in that~~
~~the further comprising a step of sealing a top end of the bags is~~
~~also sealed using bag by~~ transverse sealing.

7. (Currently amended) ~~Process pursuant~~ The process according to
claim ~~1~~ 5,
~~characterized in that~~
wherein the step of forming the bag is formed and filled partly the
step of filling the bag are performed in a form, fill, and seal
machine.

8. (Currently amended) ~~Process pursuant~~ The process according to
claim 1,
~~characterized in that~~
~~a film tube (25, 40) is used in which~~ wherein at least one part of
the four seams of the film tube is formed by a joining process in
which additional adhesive or extrudate joining material, ~~such as~~
~~adhesives or extrudates,~~ is applied on the seam ~~(27)~~.

9. (Canceled)

10. (Currently amended) ~~Process pursuant~~ The process according to
claim 1,

~~characterized in that~~

~~the~~ wherein a conveying direction of the four film ~~webs~~ segments to the a joining station ~~(8)~~ defines ~~the~~ a longitudinal axis of the formed film tube ~~(25, 40)~~.

11. (Currently amended) ~~Tubular~~ A tubular film roll ~~(36)~~ formed out of ~~from~~ a film tube ~~with~~ comprising four side walls ~~(A-D)~~ that are cut from a single film web and that are joined to one another using by four seams ~~(27)~~.

12. (Currently amended) ~~Tubular~~ The tubular film roll ~~(36)~~ ~~pursuant~~ according to claim 11,
~~characterized in that~~
wherein two ~~(BC)~~ of the four side walls ~~(A-D)~~ have side gussets ~~(26)~~ therein.

13. (Currently amended) ~~Tubular~~ The tubular film roll ~~(36)~~ ~~pursuant~~ according to claim 12,
~~characterized in that~~
~~the~~ wherein two front sides ~~(A, D)~~ side walls of the side-gussetted film tube ~~(25)~~ lie over one another.

14. (Currently amended) ~~Tubular~~ The tubular film roll ~~(36)~~ ~~pursuant~~ according to claim 12,
~~characterized in that~~

wherein the side gussets (26) are staved toward the a direction of
the tube an axis of the film tube.

15. (New) A method of forming a bag from a polymer and/or metal film material and filling the bag, comprising feeding the bag forming material that is in a form of a single film web from a wound roll to an unwinding station of a bag forming device, cutting the unwound film web into four film segments, connecting the four film segments to form a film tube having four outer walls that are connected respectively by four seams, sealing one end of the film tube so as to form a first sealed end of the bag, filling the formed bag, and sealing another end of the film tube so as to form a second sealed end of the filled bag.

16. (New) The method according to claim 15, wherein the four outer walls include two opposed front walls and two opposed side walls, and further comprising a step of providing a gusset in each of the side walls.

17. (New) The method according to claim 15, wherein the four film segments are conveyed to a joining station in which the step of connecting the four film segments is performed, and wherein a direction in which the four film segments are conveyed to the joining station defines a longitudinal axis of the formed bag.

18. (New) The method according to claim 15, wherein a bottom of the bag is formed by a squeezing process and a transverse sealing process, and a top of the bag is formed by a transverse sealing process.

19. (New) The method according to claim 15, wherein the seam is formed by applying an adhesive or a weld to adjacent cut film segments so as to join the segments.

20. (New) The method according to claim 15, wherein the seam is formed by applying a heated extrudate to an edge of adjacent cut film segments so as to join the segments.

21. (New) The method according to claim 15, wherein the four film segments are connected to form the film tube by compressing the film segments between an opposed pair of rollers.